DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026778
Date Inspected: 29-Nov-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 600
OSM Departure Time: 1430
Location: Santa Fe Springs, CA

CWI Name: Chris Concha, Ruben Dominguez

CWI Present:	☑ Yes	☐ No					
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Maintenance Travelers

Summary of Items Observed:

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

QA Inspector randomly observed Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez perform magnetic particle testing (MT) on the final assembly splice on the SAS WB Traveler and balcony modification welds. Mr. Dominguez informed this QA that he did not observe any relevant indications during his inspection.

SAS WB Traveler

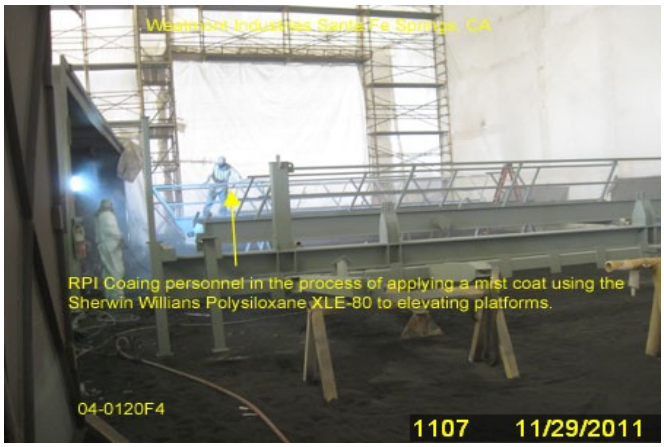
This QA Inspector randomly observed Smith Emery, CWI, QC Inspector Mr. Chris Concha performing visual inspection on the SAS WB traveler. Mr. Concha informed this QA Inspector that he had found several areas for in process grinding and welding. This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) grinding and welding areas found Mr. Concha using Flux Core Arc Welding (FCAW) process in all positions on tube steel and plate material, randomly throughout the shift. QC visual inspection and pick-up welding not completed on this date.

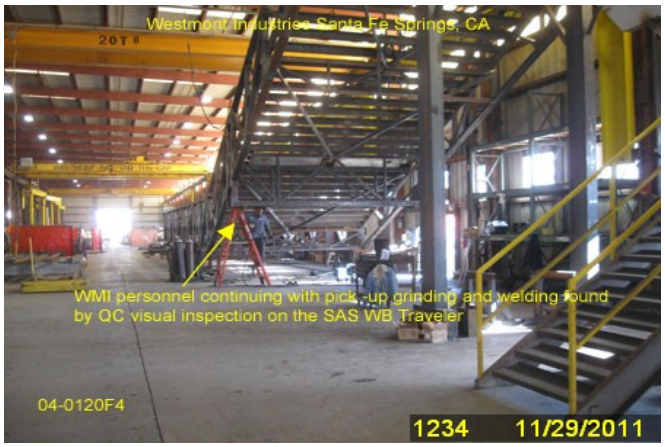
RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is on site to continue abrasive coating application on the Elevating Platforms and Bike Path Traveler Assemblies. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to apply mist coat using the Sherwin Williams Polysiloxane XLE-80 today on three (3) elevating platforms and bike path

assemblies and touch-up the top coat on the E2/E3 WB Traveler. Later in the morning this QA Inspector randomly observed that RPI personnel performing mist coat application and using the Sherwin Williams Polysiloxane XLE-80. This QA also randomly observed RPI personnel sanding, cleaning and touching up area's on the E2/E3 WB Traveler using the Sherwin Williams Polysiloxane XLE-80 top coat. Touch up on the E2/E3 WB Traveler not completed on this date. Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 58/68 F, Relative Humidity 50/45%, Wet Bulb Temperature 53/54 F, Dew point 49/45 F and Surface Temperature 54/65 F.

This QA Inspector performed measurement on dry coating thickness with Type 2 (magnetic gage), DFT's thickness reading of the prime coated surface coated on 11-29-11 are an average of three (3) thickness reading are as follows 3.9 mils, 3.5 mils, 4.8 mils 3.6 mils, 3.7 mils, and 4.0 mils.





Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Brannon,Sherri	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer